

# Work Order ID 51917

Wednesday, September 09, 2009 11:31:00 A



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*R/mk*

Date: *09-9-00* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

*Serbo/03*

*09-9-29*

**Work Order ID 51917**

Wednesday, September 09, 2009 11:31:00 A

Page 2

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 &amp; DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ Aluminum Rod

10-Grind welds flush as per Dwg D2750

AE 09/09/14

- AWM 7-9-15

m111682 AE 09/09/14

- AWM 9-9-15

# Work Order ID 51917

Wednesday, September 09, 2009 11:31:00 A



Page 3

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

27 8/21/09



08 09 16

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

27 8/21/09



08 09 16

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

27 8/21/09

08

09

16



**Work Order ID 51917**

Wednesday, September 09, 2009 11:31:00 A

Page 4

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

a.m 09 - 09 - 16 @

# Work Order ID 51917

Wednesday, September 09, 2009 11:31:00 A

Page 5

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291 batch: ☐ ☐ ☐

exp. date: 10-02-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ ☐ Aluminum Rod batch: M111682

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

BE 09/09/17

M112391 - ALM 7-9-17

Q. m 09-09-28 ①

Q. m 09-09-28 ②

**Work Order ID 51917**

Wednesday, September 09, 2009 11:31:00 A

Page 6

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11-Deburr holes G n 09-09-29

170

QC10- Inspect visual per QSI004- ground welds

0.00

2) 8 or 10 lbs



QC

Memo

0.00

(40)

/

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

2) 8 or 10 lbs



QC

Memo

0.00

(40)

/

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

1/1 09-09-29



HandFinish

Memo

0.00

(1)

Hand Finishing

# Work Order ID 51917

Wednesday, September 09, 2009 11:31:00 A

Page 7

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=> Jd 09/09/29

(X1)

Ø

Powdercoat

Memo

0.00

START TIME: 11:00AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 11:30AM

Powder Coating

210

QC3- Inspect Part Finish

0.00

BK 09-09-29

Ø

QC

Memo

0.00

Inspect for foreign object per QSI 024

Quality Control

220

HandFinishing

0.00

BK 09-09-29

Ø

HandFinish

Memo

0.00

Install inserts as per dwg D2750

Hand Finishing

# Work Order ID 51917

Wednesday, September 09, 2009 11:31:00 A



Page 8

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"  
batch: \_\_\_\_\_

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750  
SIKA FLEX 241  
BATCH: 11112391  
EXP DATE: 10/00

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 11101223

5-Coat all exposed fasteners with "LPS Procyon"  
batch: 11104251

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/24/09

BR 09-09-29. ④ -

④

⑥



**Work Order ID 51917**

Wednesday, September 09, 2009 11:31:00 A

Page 9

Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/09 10 SP

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 8/21/09

70 10

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

Rev 4

9/9/29 10 SP

**Work Order ID 51917**

Wednesday, September 09, 2009 11:31:00 A



Page 10

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/29 *[Signature]*

MF 09-09-29

# Picklist Print

Wednesday, September 09, 2009 11:31:06 AM

Page 1

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,753.000	38.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8753	
107441	16	
110768	8737 ✓	

AN3C5A

Purchased

No

230

Each

642.0000

34.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	642	
111424	8	
111707 ✓	334	
112314	200	
112489	100	

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1048	
110372 ✓	72	
111982	976	

38 BR 09-09-29,

34 BR 09-09-29

4 BR 09-09-29

# Picklist Print

Page 2

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6C44A		Purchased	No			230	Each	172.0000	4.0000			
---------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



BOLT

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865 ✓

51

111605

50

111649

50

4 BL 09-09-09

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

167

102180

1

106896

1

110105 ✓

65

110847

100

1 BL 09-09-09

Wednesday, September 09, 2009 11:31:07 AM

Shop Packet Print

Page 2

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			230	Each	7,340.000	38.0000			
												
washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	7240	
112116	2240	
112612 ✓	5000	

38. BL 09-09-09

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372 ✓	36	
110584	100	
111424	159	

BL 1 09-09-09

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
												

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	272	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	19	
43754	2	
44893	37	
45556 ✓	69	
46695	18	
48278	110	

8 pk 09-09-09

D3488-042RevB

Manufactured No

230

Each

9.0000

1.0000



Blade Fitting Assembly, RH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
29043	1	
44531 ✓	8	

1 Bl 09-09-09

# Picklist Print

Page 5

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041RevC		Manufactured	No			230	Each	3.0000	8.0000			

Plug Assembly

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

43816

3

3

230

Each

0.0000

8.0000

D3492-043RevC

Manufactured

No



Plug Assembly

D3535-25RevB

Manufactured

No



Wearshoe

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

47523

11

11

230

Each

11.0000

1.0000

8 BR 09-09-29

8 BR 09-09-29

1 BR 09-09-29

Wednesday, September 09, 2009 11:31:07 AM

Shop Packet Print

Page 5

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
45569	1	
47011	2	
47526	8	
50266 ✓	10	

1 32 09-09-09

D3537-1RevC

Manufactured No

230

Each

45.0000

3.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	45	
48288 ✓	2	
50321 ✓	43	

3 16 09-09-09



# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA		Manufactured	No			230	Each	105.0000	8.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	105	
38139	6	
45353	16	
47437✓	83	

8. 9/10/09-09

D3791-1RevA

Manufactured No

230

Each

18.0000

1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
47536✓	8	
50269	10	

1 9/10/09-09

# Picklist Print

Page 8

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
40551	1	
47537	4	
50231 ✓	13	

D3793-3RevA

Manufactured No

230

Each

22.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
47720 ✓	11	
50216	11	

1 BL0909-29

1 BL0909-29

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA 		Manufactured	No			230	Each	33.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
46530	1	
47212	2	
47721	4	
51668 ✓	26	

1 Bl 09-09-29

D3794-3RevA



Manufactured No

230 Each 27.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
46531	2	
47440	2	
47722 ✓	11	
50240	12	

1 Bl 09-09-29

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-6		Purchased	No			230	Each	1,132.000	4.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1132

110584 ✓

34

111424

98

112314

1000

4 BR0909-29.

MS21083C8		Purchased	No			230	Each	90.0000	1.0000			
-----------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

90

110584

5

111424

2

111637 ✓

21

112243

42

112492

20

1 BR09-09-29.

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

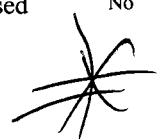
Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010 		Purchased	No			230	Each	345.0000	8.0000			
O-RING												



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

PTO D2594-3 →

345

110715

50

110915

295

Plb

~~11/11/09~~

NAS1611-013



Purchased

No

230

Each

320.0000

8.0000

O-RING



Page

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424 ✓

109

111758

200

8 B/09-09-09.

B# 51917

P/N: D350-636-012

~~TO CHANGE~~

~~WAS 161-010 FOR D3594-4~~

~~(8X) BA 51613~~

~~OK 09-09-39~~

See w/o change sheet

W/O: 51917

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/29		Replace NAS 1611-010 For D2596-4 O-rings M51613.	BK	09-09-29	3		S 09/09/29

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 12

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A 		Purchased	No			260	Each	110.0000	2.0000			
BOLT												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	110	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	50	

111684 54

AN960C816L

Purchased

No

260

Each

330.0000 2.0000



WASHER

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 54

9/9/09 12

Wednesday, September 09, 2009 11:31:07 AM

Shop Packet Print

Page 12



# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC		Manufactured	No			260	Each	40.0000	1.0000			
Blade, 350 Skidtube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

47113 SY

D3493-1RevA		Manufactured	No			260	Each	115.0000	2.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

44902 SP

D3532-1RevA		Manufactured	No			260	Each	43.0000	2.0000			
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

9/9/09 R

44904 SY

# Picklist Print

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	90.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

112243 SP

NAS1515H3L



Purchased

No

260

Each

350.0000

4.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819 ✓	300	

4 Bl 09-09-2009

# Picklist Print

Page 15

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L WASHER		Purchased	No			260	Each	127.0000	2.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	127	
107581	34	
108964	1	
111650	92	

D2600-3-BENTRevD1	Manufactured	No				110	Each	0.0000	1.0000			
Extrusion Bent												
D2744RevC	Manufactured	No				110	Each	50.0000	1.0000			
Cap												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	50	
44892	15	
47488	35	

111650 SV  
B50675 BE 09/09/14  
~~B50675 BE 09/09/14~~  
r BE 09/09/14

# Picklist Print

Page 16

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD  350 I Beam		Manufactured	No			160	Each	6.0000	1.0000			

*B-51919 ANN 7-9-17*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

D2743RevB

Manufactured No

160

Each

294.0000

8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	50	
50281	50	
Main Warehouse		
ST	244	
44891	2	
45555	177	
48275	65	

*8 BE 9-9-21*

# Picklist Print

Page 17

Wednesday, September 09, 2009 11:31:07 AM

Work Order ID: 51917



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA		Manufactured	No			160	Each	112.0000	4.0000			

Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 112

45560 22

47471 35

48276 55

*4 BE 9-9-21*

D3490-1RevA

Manufactured No

160

Each

165.0000

4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 165

45338 2

47118 4

47657 50

48277 109

*4 BE 9-9-21*

Wednesday, September 09, 2009 11:31:07 AM

Shop Packet Print

Page 17

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

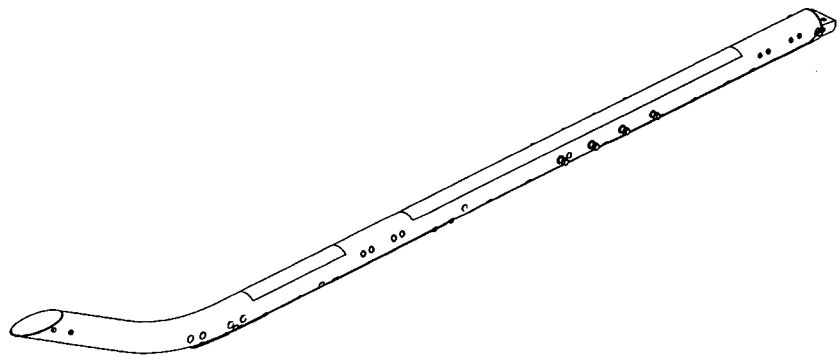
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51917

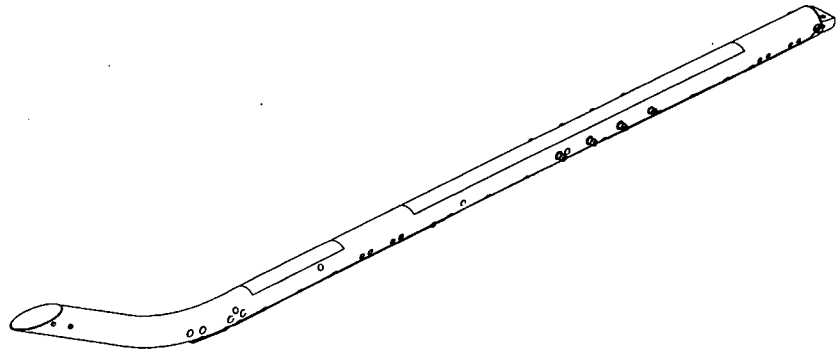
RELEASED  
62 07 22 14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3781-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCK 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 1 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O 51917



D2750-041 350 SKIDTUBE ASSEMBLY, LH

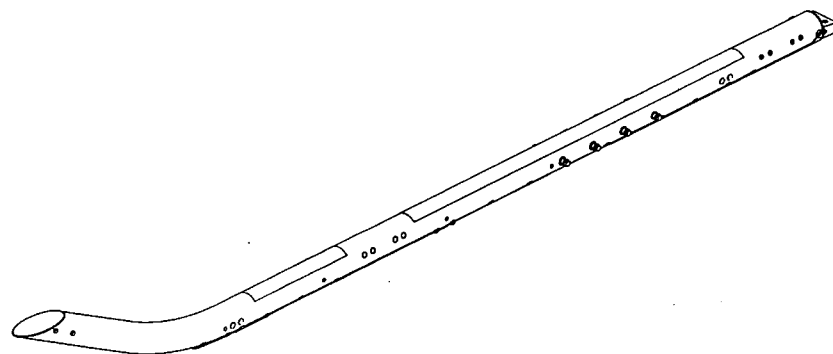


D2750-042 350 SKIDTUBE ASSEMBLY, RH

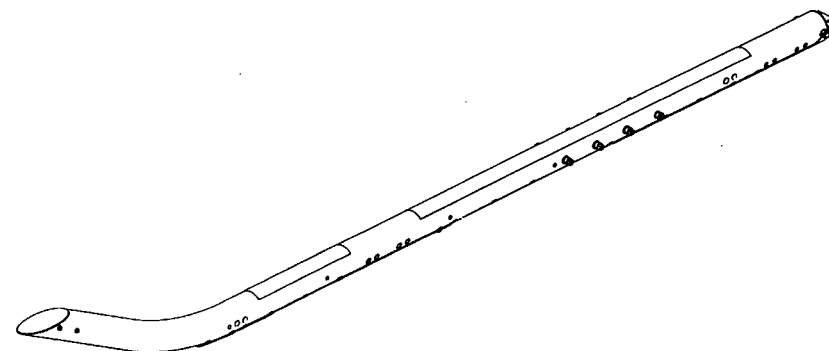
RELEASED  
08.09.12

DESIGN	PO	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AM		
CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	MP	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O 51917



D2750-043 350 SKIDTUBE ASSEMBLY, LH



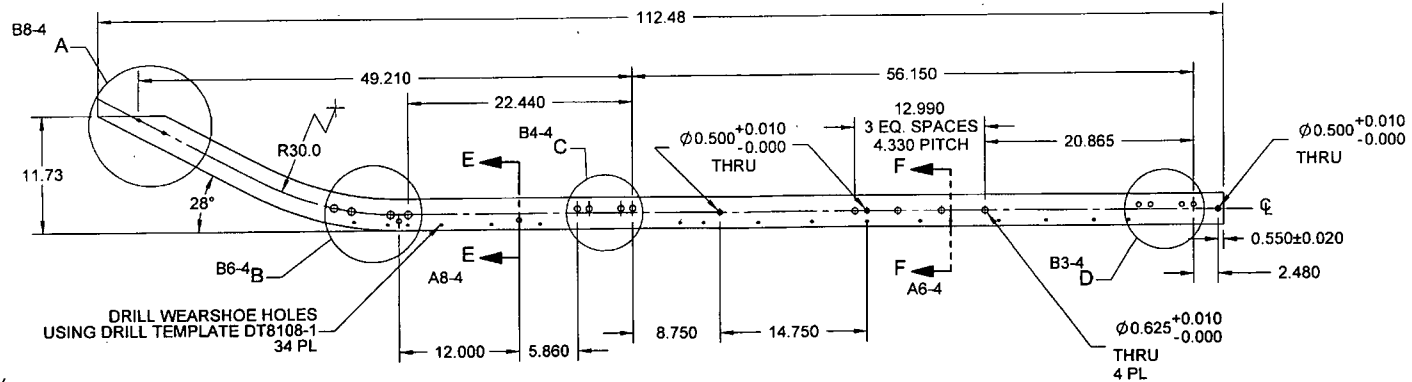
D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08-09-22/1.1.1

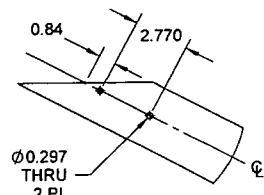
DESIGN	PW	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PW	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	SA	SHEET 3 OF 11	
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



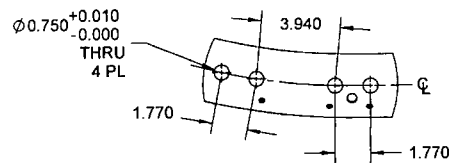
W/O 51917



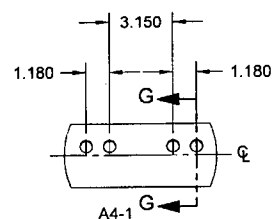
**D2750-1 LH SKIDTUBE**



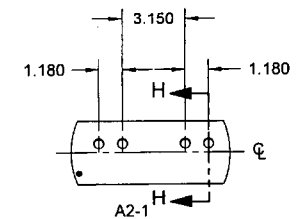
**DETAIL A**  
SCALE 2X



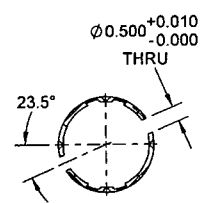
**DETAIL B**  
SCALE 2X



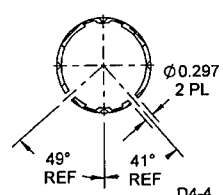
**DETAIL C**  
SCALE 2X



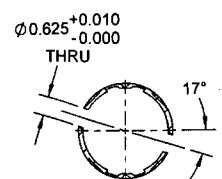
**DETAIL D**  
SCALE 2X



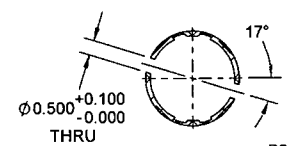
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

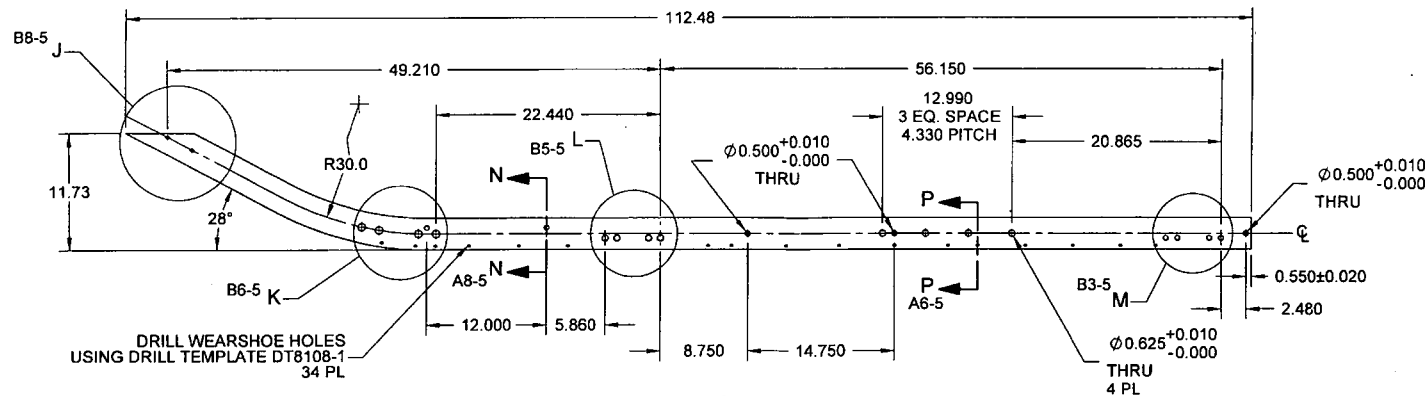


**SECTION H-H**  
SCALE 3X, 4 PL

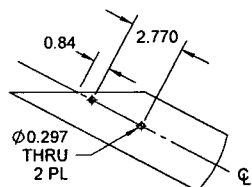
**RELEASED**

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

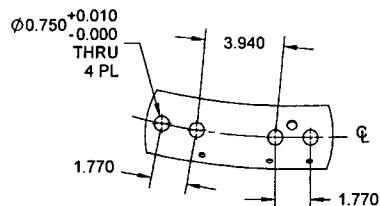
W/0 51917



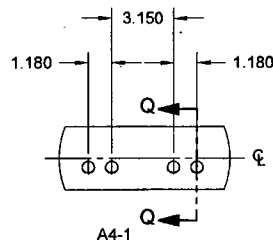
**D2750-2 RH SKIDTUBE**



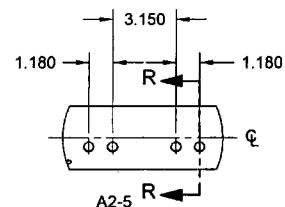
**DETAIL J**  
SCALE 2X  
D8-5



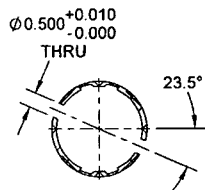
**DETAIL K**  
SCALE 2X  
C7-5



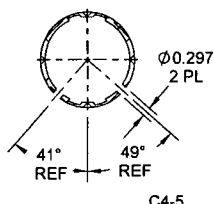
**DETAIL L**  
SCALE 2X  
D6-5



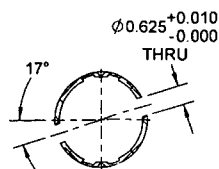
**DETAIL M**  
SCALE 2X  
C3-5



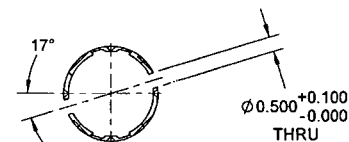
**SECTION N-N**  
SCALE 3X, 2 PL  
C6-5



**SECTION P-P**  
SCALE 3X, 17 PL  
C4-5



**SECTION Q-Q**  
SCALE 3X, 4 PL  
B5-5



**SECTION R-R**  
SCALE 3X, 4 PL  
B3-5

**RELEASED**  
08-07-16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/C 51917

8

7

6

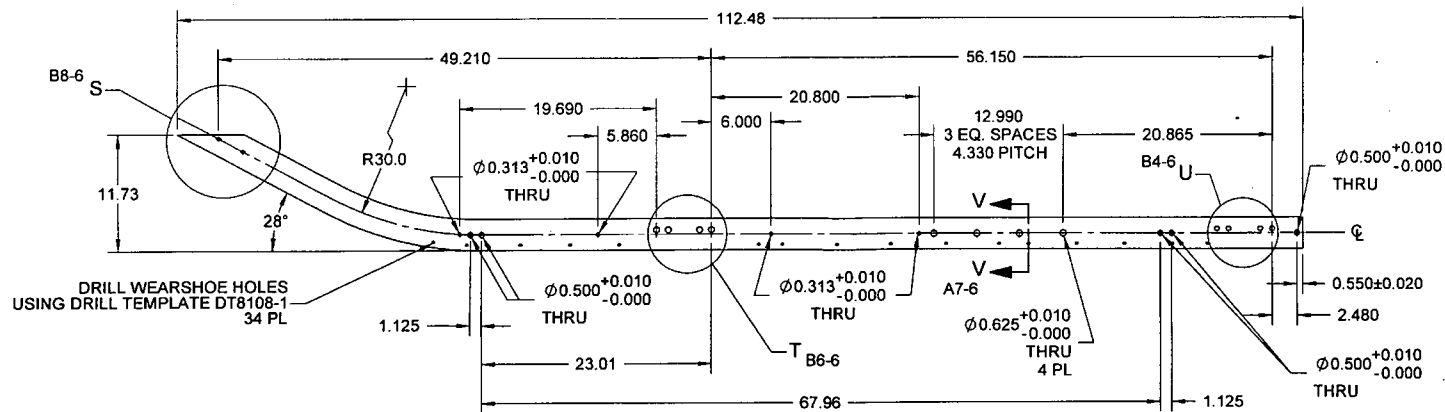
5

4

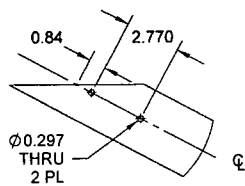
3

2

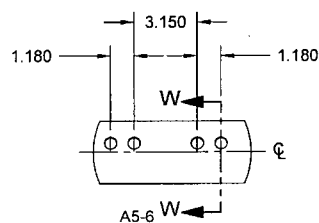
1



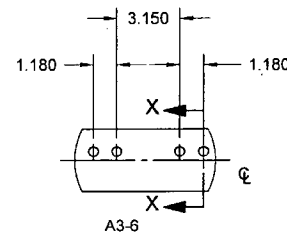
**D2750-3 LH SKIDTUBE**



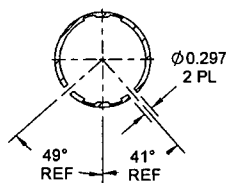
**DETAIL S**  
D8-6  
SCALE 2X



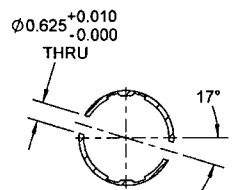
**DETAIL T**  
C5-6  
SCALE 2X



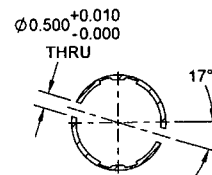
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8

7

6

5

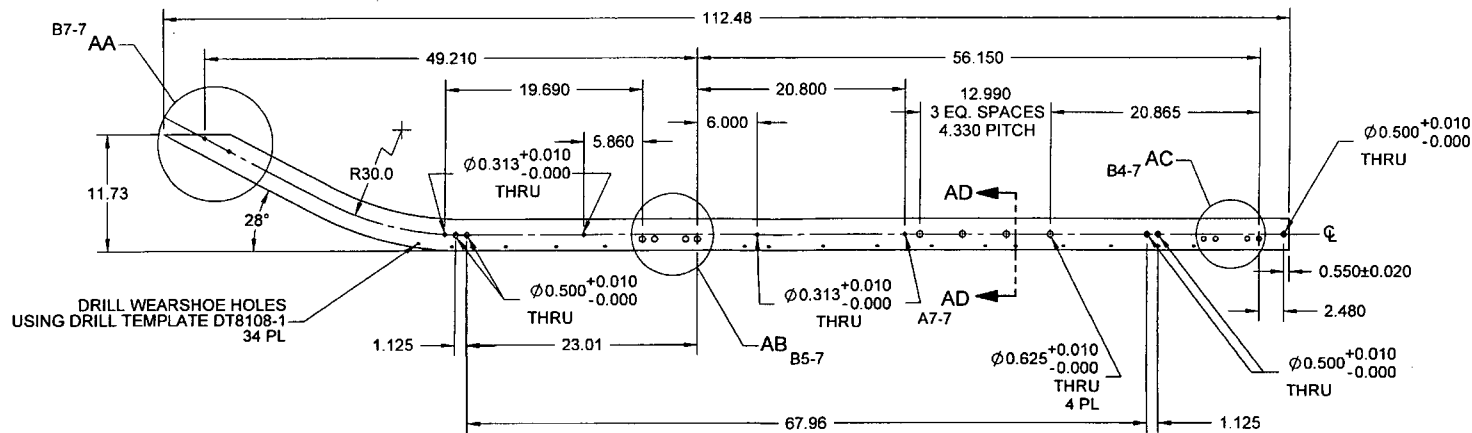
4

3

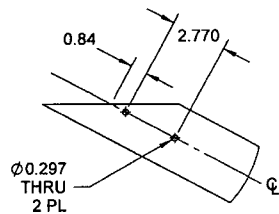
2

1

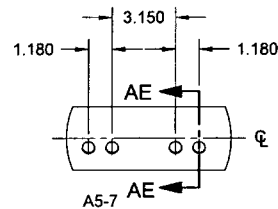
4/0 51917



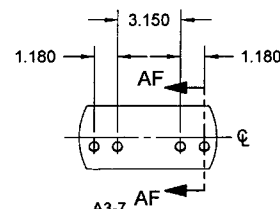
**D2750-4 RH SKIDTUBE**



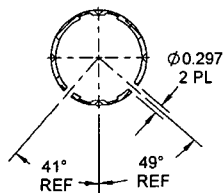
**DETAIL AA**  
SCALE 2X



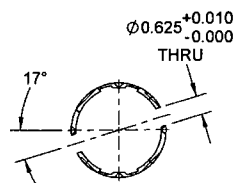
**DETAIL AB**  
SCALE 2X



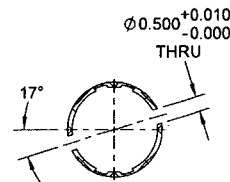
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL

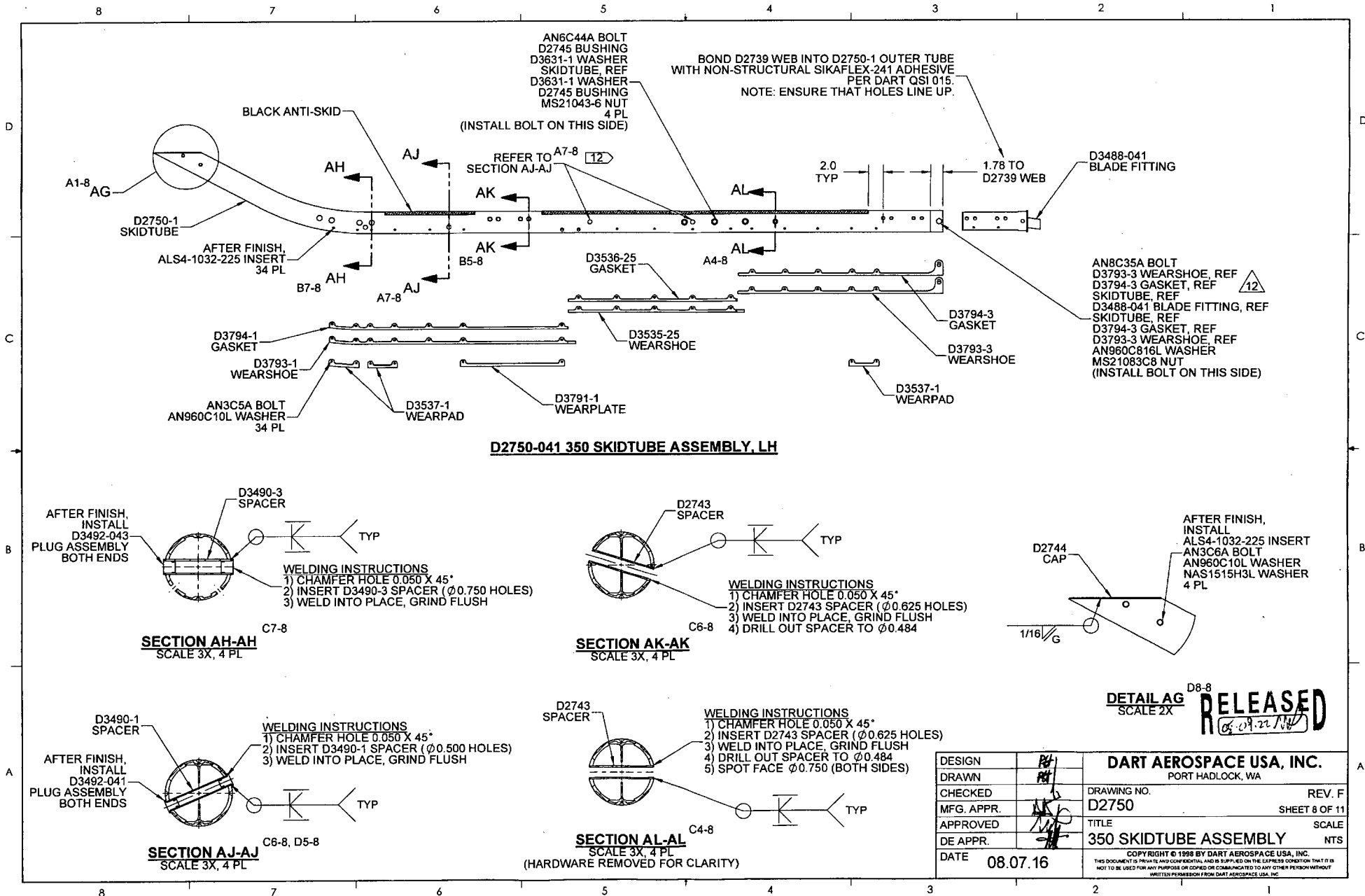


**SECTION AF-AF**  
SCALE 3X, 4 PL

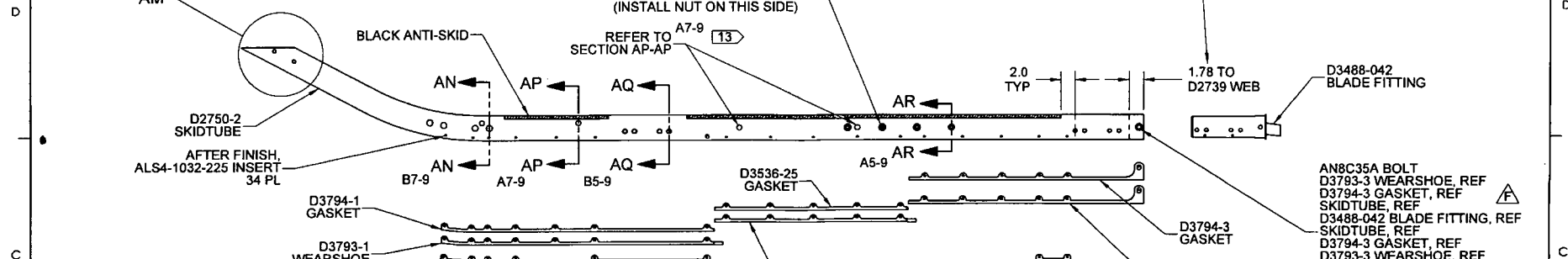
**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

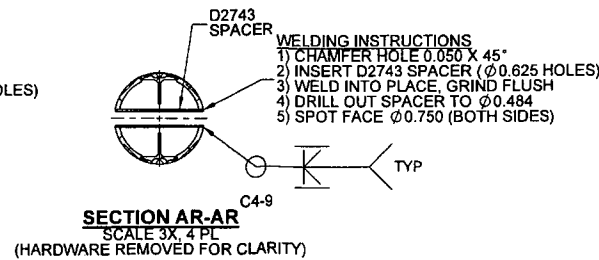
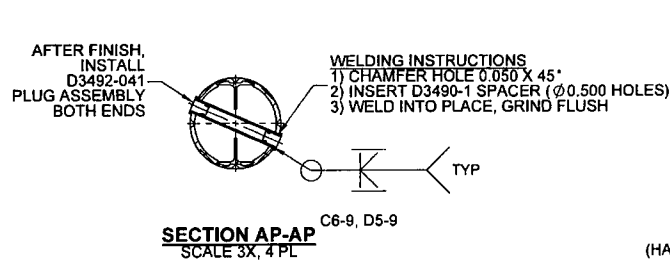
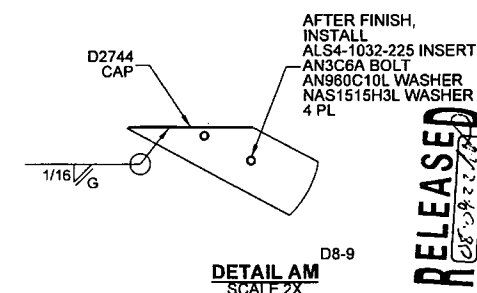
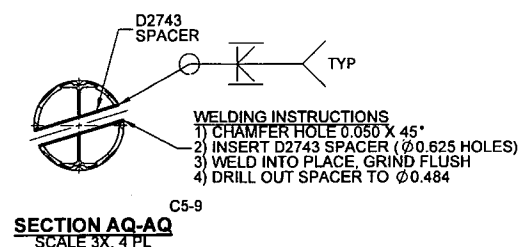
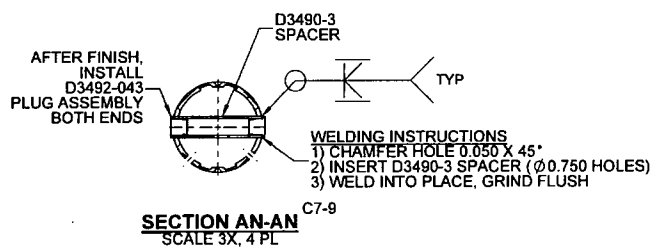
W/O 51917



8	7	6	5	4	3	2
---	---	---	---	---	---	---



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D2750</b>  TITLE <b>350 SKIDTUBE ASSEMBLY</b>  COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE &amp; UNCLASSIFIED. IT IS SUPPLIED UNDER THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV.
DRAWN	PH		SHEET 9 OF 11
CHECKED			SCALE
MFG. APPR.	MD		NTS
APPROVED			
DE APPR.			
DATE	08.07.16		

DESIGN	<i>Handwritten: 10</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>Handwritten: 10</i>	PORT HADLOCK, WA	
CHECKED	<i>Handwritten: 10</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>Handwritten: 10</i>	D2750	SHEET 10 OF 10
APPROVED	<i>Handwritten: 10</i>	TITLE	SCALE
DE APPR.	<i>Handwritten: 10</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED TO THE CUSTOMER UNDER THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

**SECTION BB-BB**  
SCALE 3X, 4 PL

**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**SECTION BC-BC**  
SCALE 3X, 4 PL

**SECTION BE-BE**  
SCALE 3X, 4 PL

**DETAIL BA**  
SCALE 2X

**WELDING INSTRUCTIONS**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø0.484

**WELDING INSTRUCTIONS**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

**WELDING INSTRUCTIONS**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

**RELEASED**

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

**DRAWING NO. D2750**

**TITLE 350 SKIDTUBE ASSEMBLY**

**DATE 08.07.16**

**REV. F**  
SHEET 11 OF 11  
SCALE NTS

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

AFTER FINISH,  
INSTALL  
ALS4-1032-225 IN SERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL

**DETAIL BA**  
**SCALE 2X**

DESIGN	<i>MS</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>MS</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>MS</i>	D2750	SHEET 11 OF 11
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPY RIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



NO. 203

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: 5011  
Part number: D350 626 014  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. D. Del Date of Test Coupon 09-07-14  
Welder Barday Elliott Date of Test Coupon 09-07-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld